

CLAIMS

1. A method of reducing or eliminating bondline failures in articles of manufacture constructed with an adhesive, which articles contain residual stress prior to cure of the adhesive, said method comprises using as the adhesive a reactive hot melt adhesive comprising from about 0 to about 60 parts of a polyether polyol, from about 0 to about 40 parts of a polyester polyol, from about 1 to about 75 parts of a functional acrylic, from about 0 to about 30 parts of a non-reactive acrylic, and from about 2 to about 25 parts of an isocyanate.
2. The method of claim 1 wherein the adhesive comprises from about 15 to about 25 parts of a polyester polyol, from about 15 to about 50 parts of a functional acrylic, and from about 2 to about 25 parts of an isocyanate.
3. The method of claim 2 wherein the adhesive further comprises a polyether polyol and a non-reactive acrylic.
4. The method of claim 1 further comprising a catalyst.
5. The method of claim 4 wherein the catalyst is DMDEE.
6. The method of claim 1 wherein the adhesive further comprises an additive.
7. A method of bonding substrates together, which materials are subject to stress prior to adhesive cure, said method comprising applying a reactive hot melt adhesive composition in a liquid form to a first substrate, bringing a second substrate in contact with the composition applied to the first article, and subjecting the applied composition to conditions which will all the composition to cool and cure to an irreversible solid form, said conditions comprising

moisture, wherein the adhesive composition comprises from about 0 to about 60 parts of a polyether polyol, from about 0 to about 40 parts of a polyester polyol, from about 1 to about 75 parts of a functional acrylic, from about 0 to about 30 parts of a non-reactive acrylic, and from about 2 to about 25 parts of an isocyanate.

8. The method of claim 7 wherein the adhesive comprises from about 15 to about 25 parts of a polyester polyol, from about 15 to about 50 parts of a functional acrylic, and from about 2 to about 25 parts of an isocyanate.

9. The method of claim 8 wherein the adhesive further comprises a polyether polyol and a non-reactive acrylic.

10. The method of claim 7 further comprising a catalyst.

11. The method of claim 10 wherein the catalyst is DMDEE.

12. The method of claim 10 wherein the adhesive further comprises an additive.

13. An article of manufacture prepared by the method of claim 7.